

**Work Order ID 94575****\*94575\***

Page 1

December-19-12 12:53:07 PM

Item ID: D3179-041

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Fwd Litter Tie Down

Stop

**\*NS2\***

Start Date: 1/15/13 Start Qty: 4.00

**\*4\***

Cust Item ID:

Required Date: 1/15/13 Req'd Qty: 4.00

**\*4\***

Customer:

Reference:

Approvals:	Process Plan:	<i>PJ</i>	Date: <u>13-01-2</u>	Tooling:		Date:		Run	Start	<b>*NR1*</b>
	QC:		Date:	SPC (Y/N):		Date:		Stop		<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3179	Rev C								
100		0.00							
<b>*100*</b>	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 12.150" long								
			<i>13-01-07</i>			4	Ø		
110		0.00							
<b>*110*</b>	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	I- Mill as per Folio FA297 Rev: <u>A</u> & Dwg D3179-1 Rev: <u>C</u> 2- Deburr per dwg D3179-1								
			<i>0fe/b. 2013-01-08</i>			4	Ø		<i>DA 25 89</i>
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
<b>*120*</b>	Memo	0.00							
QC									
Quality Control									
			<i>0fe/b. 2013-01-08</i>			4	Ø		<i>DA 25 89</i>

NCR: Yes / No

## WORK ORDER NON-CONFORMANCE / UPDATE

DOA: ✓ Date: 20/3/01/23  
 QA Closed: ✓ Date: 11

Work Order: <u>94575</u>	DISPOSITION	AGAINST DEPARTMENT/PROCESS			
Part No. <u>D3179-041</u>	Rework <input type="checkbox"/> Scrap <input checked="" type="checkbox"/> Use-as-is <input checked="" type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input checked="" type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>
NCR No. <u>13-2232</u>					

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data									
Equip/Tooling									
Operator									
Material	<u>X</u>	<u>100</u>	<u>4</u>	<u>Extrusion is thicker than diag. 0.375 dim starts at 0.390 and tapers to 0.430 at rad.</u>	<u>DAS 12 0-89 13/1/8</u>	<u>Acceptable. No effect on fit. MS27039 screw will still fit.</u>	<u>DAS 16 0-89 13/1/8</u>	<u>DAS 16 0-89 13/1/8</u>	<u>DAS 16 0-89 13/1/8</u>
Setup									
Other									
Process									
Supplier									
Training									
Unapproved									

## FAULT CATEGORY

Landing Gear	Bending	General	Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	Bend	Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	BOM/Route	Inspection Incomplete	<input checked="" type="checkbox"/> Part Incorrect	Weld
	Crushed/Crimped.	Broken/Damaged	Instructions Incomplete/Unclear	Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Burrs	Maintenance	Part Moved	
	Heat Treat	Contamination	Mislabeled	Positioned Wrong	
	Inspection Strip in Tube	Countersink	Misread	Power Loss/Surge	
	Ripples in Bend	Cut Too Short	Offset		
	Torque Waves in Extrusion	Drill Holes	Out of Calibration		
	Turning Sequence	Drawing	Out of Sequence		
	Wave/Twist in Tube	Finish	Outside Dimensions		
		Folio			

Work Order ID 94575

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Page 2

Item ID: D3179-041

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Fwd Litter Tie Down

Stop

\*NS2\*

Start Date: 1/15/13 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 1/15/13 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

ark 13/01/10

4 0

\*130\*

QC

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

4 13-1-11

\*140\*

HandFinish

Hand Finishing

150

QC3- Inspect Part Finish

0.00

4 13/01/14

\*150\*

QC

Quality Control

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: Date:

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
				Bending <input type="checkbox"/>	Grain <input type="checkbox"/>	Ovalized <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>				
				Centre Not Concentric to O/S <input type="checkbox"/>	Hardware <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>				
				Cracks <input type="checkbox"/>	Inspection Incomplete <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Weld <input type="checkbox"/>				
				Crushed/Crimped. <input type="checkbox"/>	Burrs <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>				
				Cuffs <input type="checkbox"/>	Contamination <input type="checkbox"/>	Part Moved <input type="checkbox"/>					
				Heat Treat <input type="checkbox"/>	Countersink <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>					
				Inspection Strip in Tube <input type="checkbox"/>	Cut Too Short <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>					
				Ripples in Bend <input type="checkbox"/>	Drill Holes <input type="checkbox"/>		Other <input type="checkbox"/>				
				Torque Waves in Extrusion <input type="checkbox"/>	Drawing <input type="checkbox"/>						
				Turning Sequence <input type="checkbox"/>	Finish <input type="checkbox"/>						
				Wave/Twist in Tube <input type="checkbox"/>	Folio <input type="checkbox"/>						
Instructions: Check all applicable boxes.											

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**Item ID:** D3179-041

**Accept**

**\*N900040100\***

**Setup Start \*NS1\***

**Revision ID:**

**Stop \*NS2\***

**Item Name:** Fwd Litter Tie Down

**Start Date:** 1/15/13    **Start Qty:** 4.00    **\*4\***

**Cust Item ID:**

**Required Date:** 1/15/13    **Req'd Qty:** 4.00    **\*4\***

**Customer:**

**Reference:**

**Approvals:**

**Process Plan:**

*PJ*

**Date:** 13-01-2

**Tooling:**

**Date:**

**Run Start \*NR1\***

**QC:**

**Date:**

**SPC (Y/N):**

**Date:**

**Stop \*NR2\***

**Sequence ID/  
Work Center ID**

**Operation  
Description**

**Set Up/  
Run Hours**

**Tool ID**

**Tool #**

**Plan  
Code**

**Accept  
Qty**

**Reject  
Qty**

**Reject  
Number**

**Insp.  
Stamp**

160

**\*160\***

Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

*M123383*

0.00

*H d P 13-1-14*

Memo

*1.05*

0.00

START TIME:

*3:00*

OVEN TEMPERATURE:

*1.85.*

170

**\*170\***

QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

*4x* *GB/01/15*

180

**\*180\***

Small Fab

Small Fab

Small Fab

0.00

Memo

0.00

Assemble as per Dwg D3179

*Open Date 6.244 (DAS  
22  
88)*

*13.01.15*

*4x* *GB/01/15*

NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: Date:

QA Closed: Date:

Work Order:				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			
Part No. _____ NCR No. _____											
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data	<input type="checkbox"/>										
Equip/Tooling	<input type="checkbox"/>										
Operator	<input type="checkbox"/>										
Material	<input type="checkbox"/>										
Setup	<input type="checkbox"/>										
Other	<input type="checkbox"/>										
Process	<input type="checkbox"/>										
Supplier	<input type="checkbox"/>										
Training	<input type="checkbox"/>										
Unapproved	<input type="checkbox"/>										
FAULT CATEGORY											
Landing Gear				General							
Bending	<input type="checkbox"/>	Bend	<input type="checkbox"/>	Grain	<input type="checkbox"/>	Ovalized	<input type="checkbox"/>	Pressure/Forced			
Centre Not Concentric to O/S	<input type="checkbox"/>	BOM/Route	<input type="checkbox"/>	Hardware	<input type="checkbox"/>	Over/Under tolerance	<input type="checkbox"/>	Temperature/Cure			
Cracks	<input type="checkbox"/>	Broken/Damaged	<input type="checkbox"/>	Inspection Incomplete	<input type="checkbox"/>	Part Incorrect	<input type="checkbox"/>	Weld			
Crushed/Crimped.	<input type="checkbox"/>	Burrs	<input type="checkbox"/>	Instructions Incomplete/Unclear	<input type="checkbox"/>	Part Lost/Missing	<input type="checkbox"/>	Wrong Stock Pulled			
Cuffs	<input type="checkbox"/>	Contamination	<input type="checkbox"/>	Maintenance	<input type="checkbox"/>	Part Moved	<input type="checkbox"/>				
Heat Treat	<input type="checkbox"/>	Countersink	<input type="checkbox"/>	Mislabeled	<input type="checkbox"/>	Positioned Wrong	<input type="checkbox"/>				
Inspection Strip in Tube	<input type="checkbox"/>	Cut Too Short	<input type="checkbox"/>	Misread	<input type="checkbox"/>	Power Loss/Surge	<input type="checkbox"/>				
Ripples in Bend	<input type="checkbox"/>	Drill Holes	<input type="checkbox"/>	Offset	<input type="checkbox"/>	Other	<input type="checkbox"/>				
Torque Waves in Extrusion	<input type="checkbox"/>	Drawing	<input type="checkbox"/>	Out of Calibration	<input type="checkbox"/>		<input type="checkbox"/>				
Turning Sequence	<input type="checkbox"/>	Finish	<input type="checkbox"/>	Out of Sequence	<input type="checkbox"/>		<input type="checkbox"/>				
Wave/Twist in Tube	<input type="checkbox"/>	Folio	<input type="checkbox"/>	Outside Dimensions	<input type="checkbox"/>		<input type="checkbox"/>				

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Page 4

**Item ID:** D3179-041

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

**Revision ID:**

**Item Name:** Fwd Litter Tie Down

**Start Date:** 1/15/13    **Start Qty:** 4.00

**\*4\***

**Cust Item ID:**

**Required Date:** 1/15/13    **Req'd Qty:** 4.00

**\*4\***

**Customer:**

**Reference:**

**Approvals:**

**Process Plan:**

**Date:**

**Tooling:**

**Date:**

Run

Start

**\*NR1\***

**QC:**

**Date:**

**SPC (Y/N):**

**Date:**

Stop

**\*NR2\***

**Sequence ID/  
Work Center ID**

**Operation  
Description**

**Set Up/  
Run Hours**

**Tool ID**

**Tool #**

**Plan  
Code**

**Accept  
Qty**

**Reject  
Qty**

**Reject  
Number**

**Insp.  
Stamp**

190

**\*190\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

DAS  
15  
9-89

13-1-15

4

200

**\*200\***

Packaging

Packaging

Identify as per dwg & Stock Location: 2021 0.00

0.00

4X

Sp

13-01-15.

210

**\*210\***

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

0.00

13-1-17 JJ

13-01-15

NCR: Yes / No

# **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: Date:

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend Torque Waves in Extrusion Turning Sequence Wave/Twist in Tube				Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled  <input type="checkbox"/> Other <hr/> <hr/> <hr/> <hr/> <hr/>							

# Picklist Print

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Page 1  
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**Work Order ID:** 94575

**Parent Item:** D3179-041

**Start Date:** 1/15/13

**Required Date:** 1/15/13

**Parent Item Name:** Fwd Litter Tie Down

**Start Qty:** 4.00

**Required Qty:** 4.00

**Comments:**

IPP A1 03.01.09 Added Acid etch end alodine RF  
 IPP Rev:B Added Powder Coat 07-07-04 JLM  
 IPP Rev:C 08-12-10 add part list DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2372 Quick Release		Manufactured	No			180	Each	5.0000	2	8	8	EP 13/01/15	
				<u>Location</u>			<u>Loc Qty</u>						
				GA			5						
				80274			2						
				86001			3						
D2444 Pip Pin Assembly		Manufactured	No			180	Each	7.0000	1	4	B94913 B92199	1x 7x	
				<u>Location</u>			<u>Loc Qty</u>						
				GA			3						
				88498			3						
				ST010			4						
				91616			4						
D6201 "T" Extrusion		Manufactured	No			180	f	57.4586	1.0125	4.263158	4	SL B-01-07	
				<u>Location</u>			<u>Loc Qty</u>						
				MAT028			57.45863153						
				81421			17.4586315						
				83987			20						
				89645			20						

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: Date:

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS										
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>									
NCR No. _____	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>										
	Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>										
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector						
Doc/Data															
Equip/Tooling															
Operator															
Material															
Setup															
Other															
Process															
Supplier															
Training															
Unapproved															
FAULT CATEGORY															
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge  <input type="checkbox"/> Other				<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	

# Picklist Print

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Page 2

Work Order ID: 94575

Parent Item: D3179-041

Parent Item Name: Fwd Litter Tie Down

Start Date: 1/15/13

Required Date: 1/15/13

Start Qty: 4.00

Required Qty: 4.00

MS21042L3

Purchased

No

180

Each

4,778.0000

1

4

Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	143	
122141	143	
GA	458	
122452	458	
ST314	677	
117885	32	
119017	55	
119075	138	
123265	452	
ST506	3500	
123900	3500	

MS27039-1-13

Purchased

No

180

Each

72.0000

1

4

Screw

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
GA	16	
119736	16	
ST304	56	
119736	56	

NAS1149D0332J

Purchased

No

100

Each

3,273.0000

3

12

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	393	
122973	393	
ST294	2880	
122973	2880	

NCR: Yes / No

## **WORK ORDER NON-CONFORMANCE / UPDATE**

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
				Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube <input type="checkbox"/>	Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burr <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio <input type="checkbox"/>	Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabelled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/>	Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other <input type="checkbox"/>			

DART AEROSPACE LTD	Work Order:	94575
Description: Fwd Litter Tie Down Bracket	Part Number:	D3179-1
Inspection Dwg: D3179 Rev: C		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

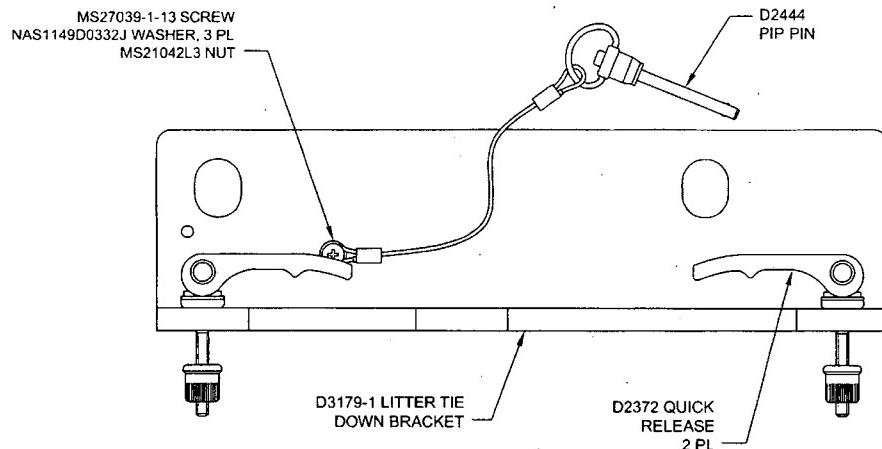
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.000	✓		KRM J-10	
Ø0.242	+0.005/-0.001	0.243	✓		-	
R0.40	+/-0.030	.40	✓			
0.375	+/-0.010	0.370 - .420				Stock
Ø0.191	+0.005/-0.001	0.192	✓			
1.00	+/-0.030	1.000	✓			
1.70	+/-0.030	1.699	✓		HG	
4.00	+/-0.030	3.999	✓			
1.50	+/-0.030	1.499	✓			
0.750	+/-0.010	0.749	✓			
1.50	+/-0.030	1.500	✓			
10.500	+/-0.010	10.500	✓		HG	
4.250	+/-0.010	4.250	✓			
0.750	+/-0.010	0.751	✓			
1.000	+/-0.010	1.001	✓			
12.00	+/-0.030	12.00			KRM CIR-02	
1.00	+/-0.030	1.000				
8.00	+/-0.030	8.00	✓			
Ø0.191	+0.005/-0.001	0.192	✓			
R0.37	+/-0.030	0.370	✓			
0.97	+/-0.030	0.971	✓			
1.86	+/-0.030	1.859	✓			
0.750	+/-0.010	0.752				
0.375	+/-0.010	0.390				Stock
2.875	+/-0.010	2.873				
0.500	+/-0.010	0.500				
1.250	+/-0.010	1.250				
1.625	+/-0.010	1.628				
3.31	+/-0.030	3.314			DAS	

Measured by:	JL	Audited by:	14 9-09	Preliminary Approval:	
Date:	13-01-07	Date:	13/01/10	Date:	

Rev	Date	Change	Revised by	Approved
A	09.04.05	New Issue P/O D3179-041	KJ/DD	
B	12.10.04	Dimension 0.750 was 1.750	KJ	

8 7 6 5 4 3 2 1

Item	Qty	Part Number	Description
1	X	D3179-041	FWD LITTER TIE DOWN
2	2	D2372	QUICK RELEASE
3	1	D2444	PIP PIN
4	1	D3179-1	LITTER TIE DOWN BRACKET
5	1	MS21042L3	NUT
6	1	MS27039-1-13	SCREW
7	3	NAS1149D0332J	WASHER (OR AN960JD10L)



9H515  
PLB-01-2



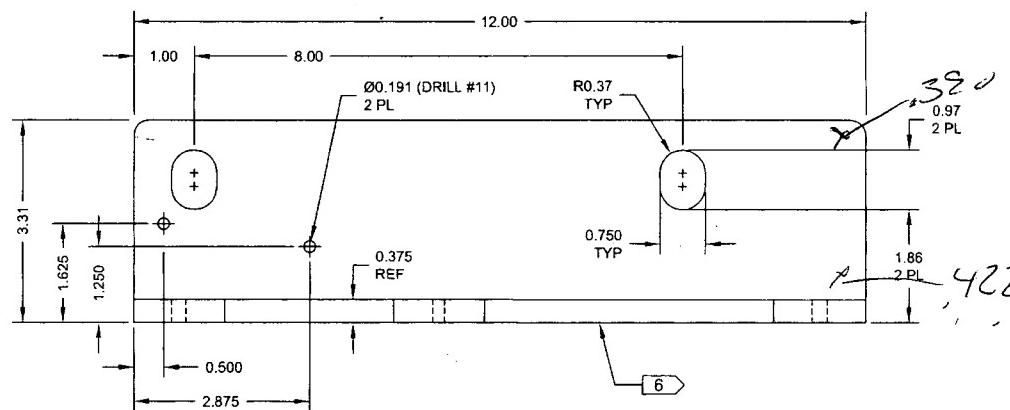
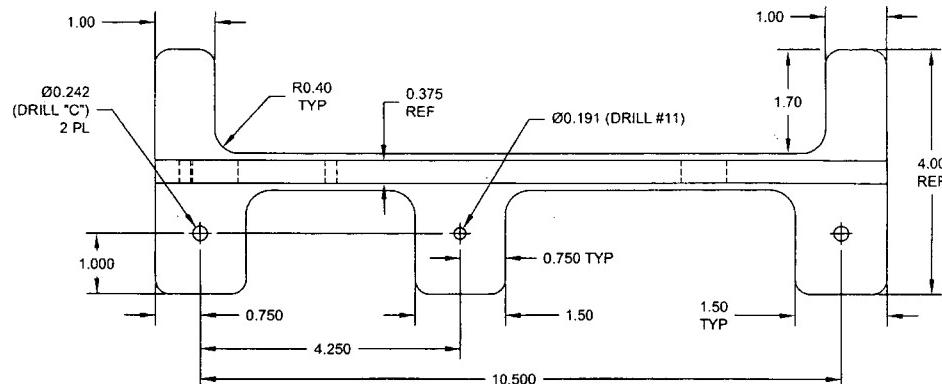
### D3179-041 FWD LITTER TIE DOWN BRACKET

RELEASER  
08/11/21 M.P.

C	ADD D3179-041 & PART LIST (ZN B6-1, D2-1); D3179-1 WAS D3179 (ZN A5-2); REMOVE ENGRAVE P/N		RF	08.11.07
B	REFORMAT DRAWING; FINISH WAS ANODIZE		DC	07.06.06
A	NEW ISSUE		RF	02.12.09
REV.	DESCRIPTION		BY	DATE
DESIGN		BW	<b>DART AEROSPACE LTD</b>	
DRAWN		RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED			DRAWING NO.	REV. C
MFG. APPR.			D3179	SHEET 1 OF 2
APPROVED			TITLE	SCALE
DE APPR.			LITTER TIE DOWN BRACKET NTS	
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**NOTES:**  
1) D3179-041 WEIGHT: 2.79 lbs

8 7 6 5 4 3 2 1



**D3179-1 LITTER TIE DOWN BRACKET**

**NOTES:**

- 1) MATERIAL: MAKE FROM D6201-012 EXTRUSION  
(6061-T6/T6511 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3179-1 USING FINE POINT  
PERMANENT INK MARKER ON THE BOTTOM FACE
- 7) WEIGHT: 2.3 lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PJ	DRAWING NO.	REV. C
MFG. APPR.		D3179	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LITTER TIE DOWN BRACKET	NTS
DATE	08.11.07	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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RELEASER  
08/11/2007